

Job Set #44



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-567-143
Job Sheet 174477



Part No: D350-567-143

Job Qty: 1 ea

Part Name: Floor Window Close Out (Energy Attenuating Seats)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/16/18

Job Tracking No:

Due Date: 4/11/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 13.04.01 AS PER DSI9590 REV:E DD VERF:JLM

Ship Via:

DAS

Chyoo

DAS
21
9-88

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/11/18	4/11/18	0.00	0.00	Start Up Stores/Pkg-2		APR 13 2018
110	Packaging	1 pcs	4/11/18	4/11/18	0.00	0.00	Packaging1-3		APR 13 2018
120	QC	1 pcs	4/11/18	4/11/18	0.00	0.00	QC4		DAS 58
125	DC	1 pcs	4/11/18	4/11/18	0.00	0.00	DC		9-88
130	Packaging	1 pcs	4/11/18	4/11/18	0.00	0.00	Packaging3-1		58 APR 15 2018
140	QC21-FG	1 Ea	4/11/18	4/11/18	0.00	0.00	QC21		DAS 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea)	90-Start up Operation	S01308
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	FM131302
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	S014745
D3802-1-024	Window Seal (\$ Per Foot)	2 Ea (2 ea)	90-Start up Operation	S01547
D4434-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	S0240902
D4434-047	Cover Assembly	1 Ea (1 ea)	90-Start up Operation	S025021680
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	S03037
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	S0377115
D4441-1-024	Rubber Seal	2 Ea (2 ea)	90-Start up Operation	15347
D4971-041	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	S060620
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	S019379
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	S044234
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	S038764
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	S052668
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	FM135603
NAS1149F0332P	Washer	10 Ea (10 ea)	90-Start up Operation	S0206023 M133
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	S00163789
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	F117316-25

Smp

Smp

2275

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	5	222	0
	AN525-10R6	2	268	0
	AN525-832R7	2	72	0
	D3802-1	2	70	0
	D4434-041	1	1	0
	D4434-047	1	3	0
	D4435-9	2	4	0
	D4436-041	1	0	0
	D4441-1	2	155	0
	D4971-041	1	0	0
	MS21042L06	7	419	0
	MS21042L08	2	2,667	0
	MS21042L3	5	2,865	0
	MS21059L3	2	161	0
	MS35206-229	7	60	0
	NAS1149F0332P	10	2,721	0
	NAS1149FN616P	14	121	0
	NAS1149FN816P	2	252	0

Part Specifications

Specifications could not be found.

Plex 3/16/18 8:17 AM Dart.Gagnon.Michelle



Container No: S060929

Part: D350-567-143

Job No: 174477

Serial No/Batch: S060929

Revision:

Inspector:

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Date: 04/13/16



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
002275	S058674	AN3-3A	Bolt	S015688	ST350	5
002275	S058673	AN525-10R6	Screw	FM137307	ST329	2
002275	S058672	AN525-832R7	Screw	S014745	ST328	2
002275	S058671	D3802-1	Window Seal (\$ Per Foot)	S015457	ST416	2
002275	S021019	D4434-041	Fwd Bracket Assembly	S021018	ST623	1
002275	S021680	D4434-047	Cover Assembly	S029922	ST619	1
002275	S051051	D4435-9	Bracket	S051050	ST091	2
002275	S060927	D4436-041	Aft Bracket Assembly	S059415	ST618	1
002275	S058670	D4441-1	Rubber Seal	F151347	ST422	2
002275	S060928	D4971-041	T/R Bellcrank Cover Assembly	S060620	ST621	1
002275	S058669	MS21042L06	Nut	S019379	ST303	7
002275	S058668	MS21042L08	Nut	S044234	ST303	2
002275	S058667	MS21042L3	Nut	S038764	ST303	5
002275	S058666	MS21059L3	Nut Plate	S052668	FG027	2
002275	S058665	MS35206-229	Screw	FM135603	ST271	7
002275	S058663	NAS1149F0332P	Washer	M133709-272	ST262	10
002275	S001037	NAS1149FN616P	Washer		ST264	7
002275	S058662	NAS1149FN616P	Washer	S019371	ST264	7
002275	S058661	NAS1149FN816P	Washer	F117316-25	ST263	2

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 4/13/18 1:18 PM dart.quirion.sonia

2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kG	1.66 m	2.94 m-kG

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED		TITLE	SCALE
DE APPR.		FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Change Record

PAGE 1 OF 1

Part Number: D350-567-143

Description: FLOOR WINDOW CLOSEOUT (ENERGY ATTENUATING SEATS)

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					